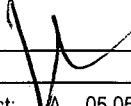
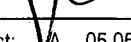


Date: Friday, 07/12/2007 7:42:47 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 36171		Part Number	: D33153	
Estimate Number	: 10747		Drawing Number	: D3315 REV. B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 07/12/2007 S.O. No. :		Drawing Revision	: B	
Prsh Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 24/12/2007	
Previous Run	: 25726			Qty:	6
Written By	: 			Um:	Each
Checked & Approved By	: 				
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET  14.2864
		Comment: Qty.: 2.4108 sf(s)/Unit Total : 14.4648 sf(s) 1010/1025/A21/6aA SHEET .060" THK BATCH: 105706 B 07-12-10
2.0	WATER JET	FLOW WATER JET   8
		Comment: FLOW WATER JET 1-Cut as per Dwg D3315 Dwg Rev: B B 07-12-10 Prog Rev: B
		2-Deburr if necessary B 07-12-10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  B 07-12-10
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK   6 07-12-10 X8
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE   SB 07-12-10 8
		Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 7:42:47 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36171

Part Number: D33153

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC6 DIMENSIONAL CHECK



✓ 7/11/18 (X8)

Comment: DIMENSIONAL CHECK

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



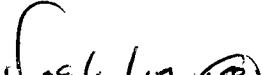
Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: 10

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M106390

FC 08/01/16 (8)

8.0 QC9 / ACS VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08/01/17 (8)

9.0 POWDER COATING POWDER COATING



M106442

(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/01/18

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT

6K 08-01-18

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-3, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: ST497

AS 08/01/18 (X8)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 08.01.21

Job Completion



U 08/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

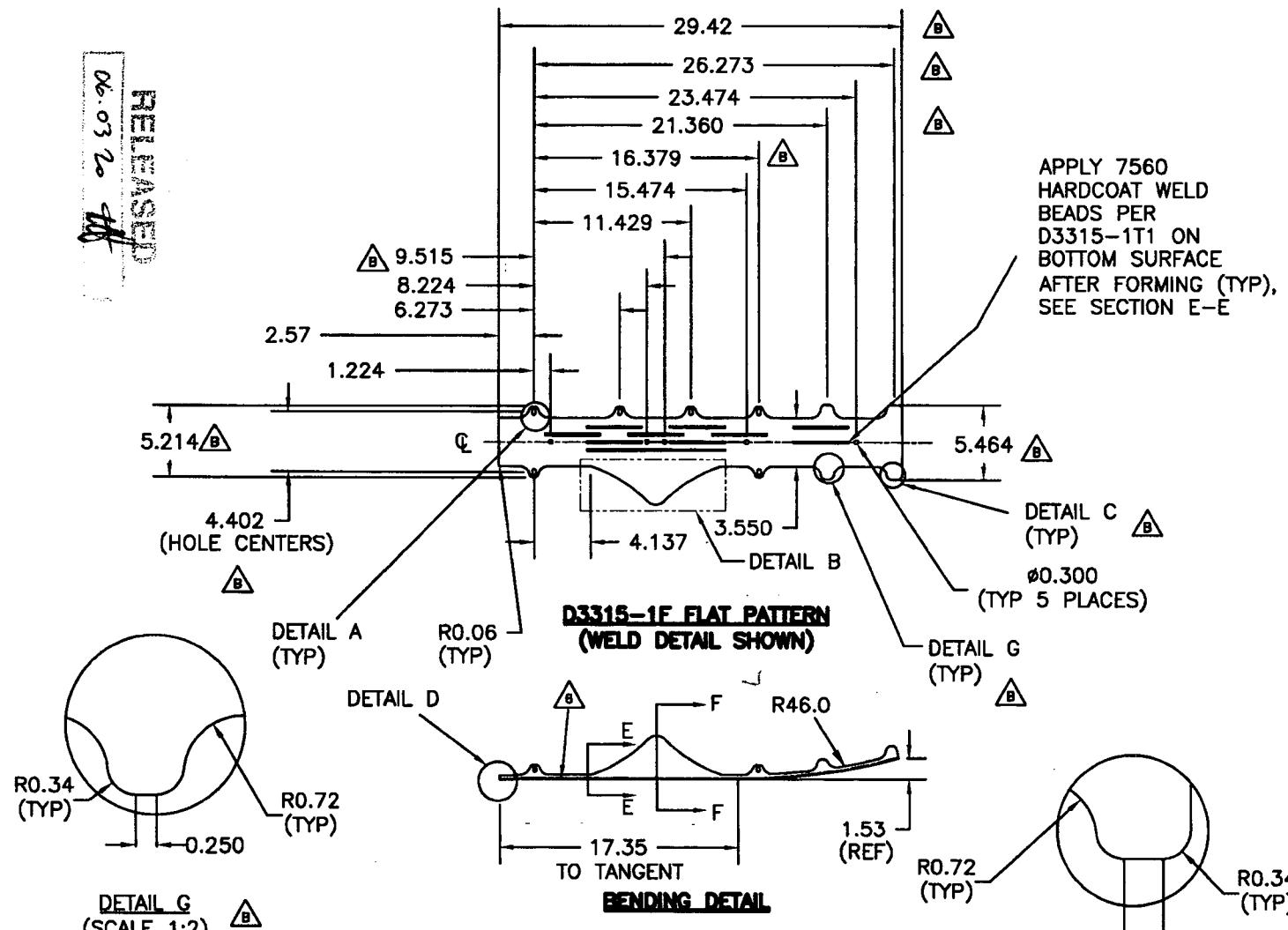
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

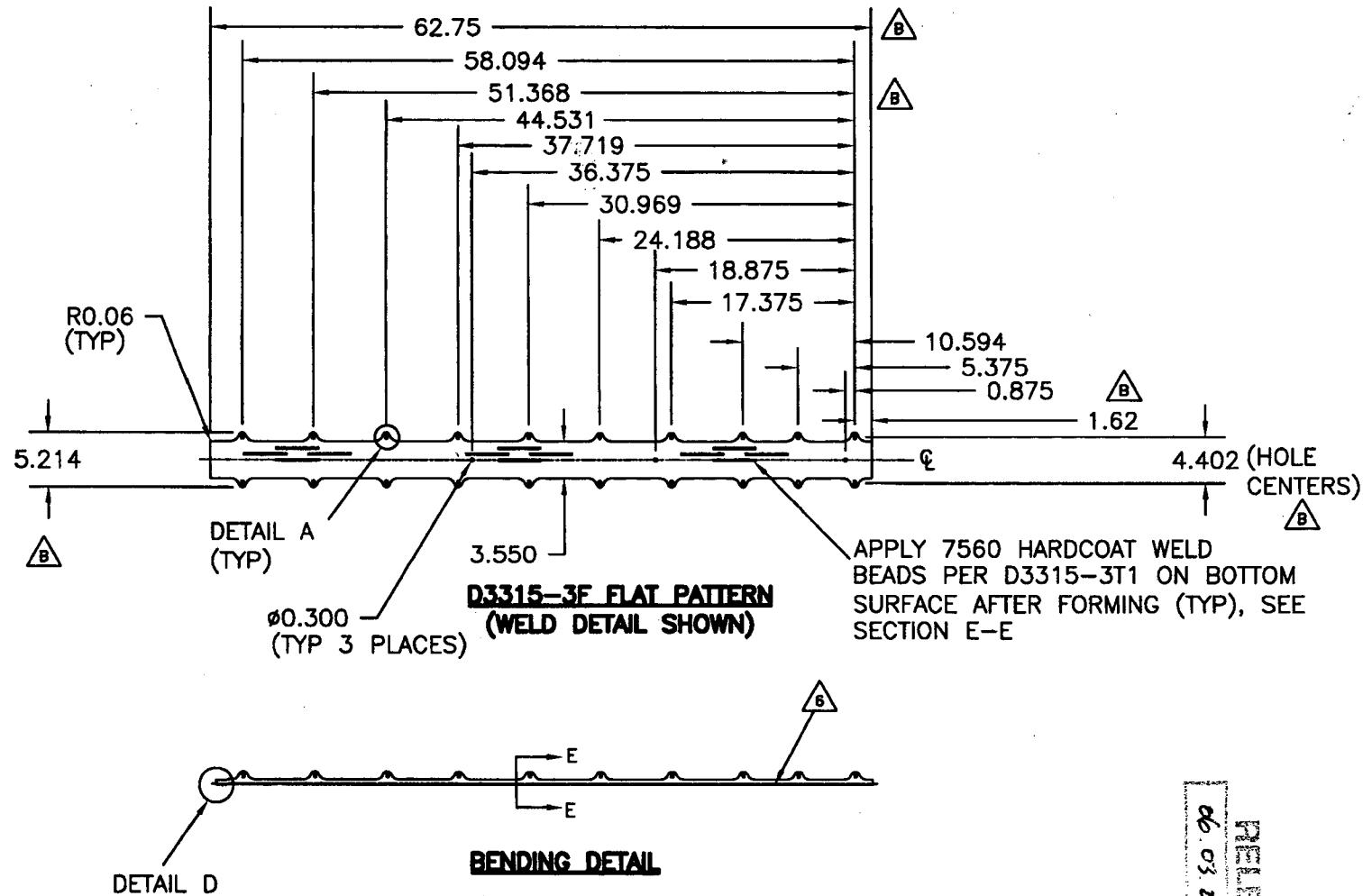
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE 06.01.31	04.09.10	TITLE D3315
A	06.01.31	WEARPLATE
B		SHEET 1 OF 4
		SCALE 1:12





D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3315	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	WEARPLATE	SCALE
06.01.31			1:16

RELEASED
06.03.20
[Signature]

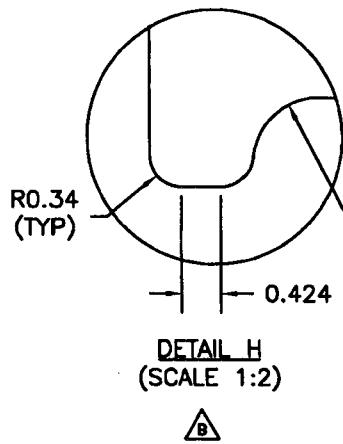
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE 06.01.31		TITLE D3315	REV. B
		SCALE 1:12	SHEET 3 OF 4

RECEIVED
06.07.2011

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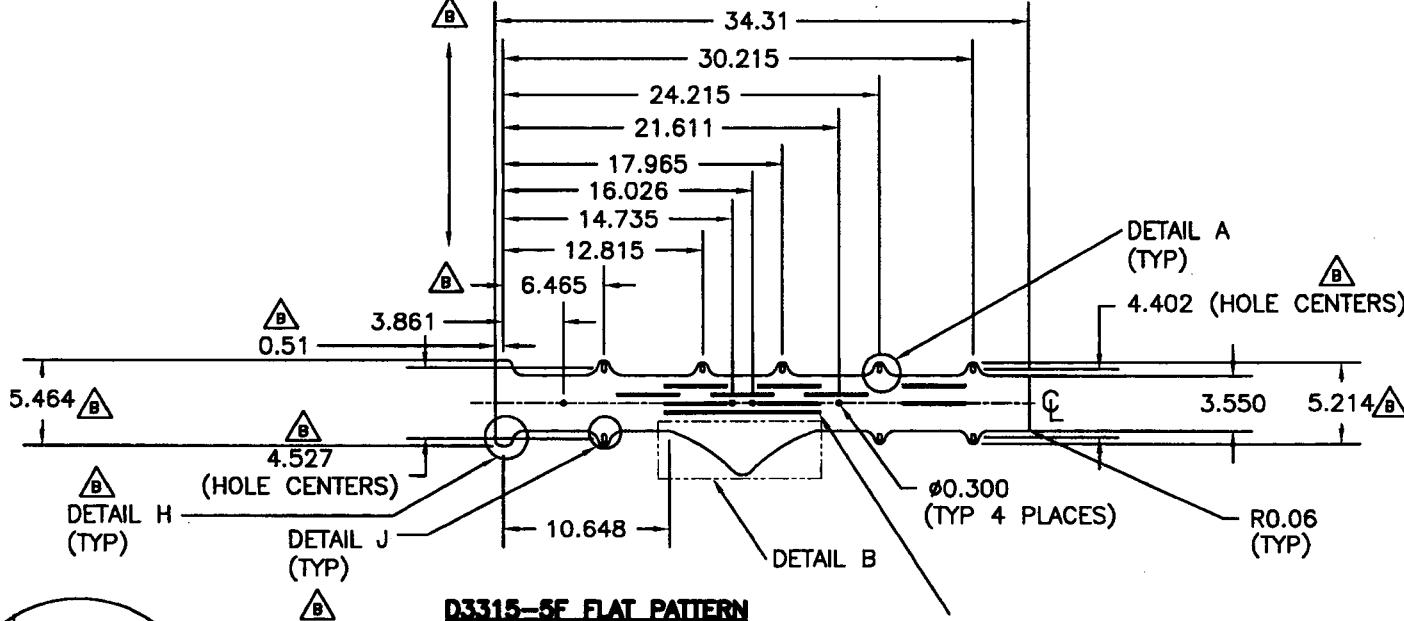


DETAIL H
(SCALE 1:2)

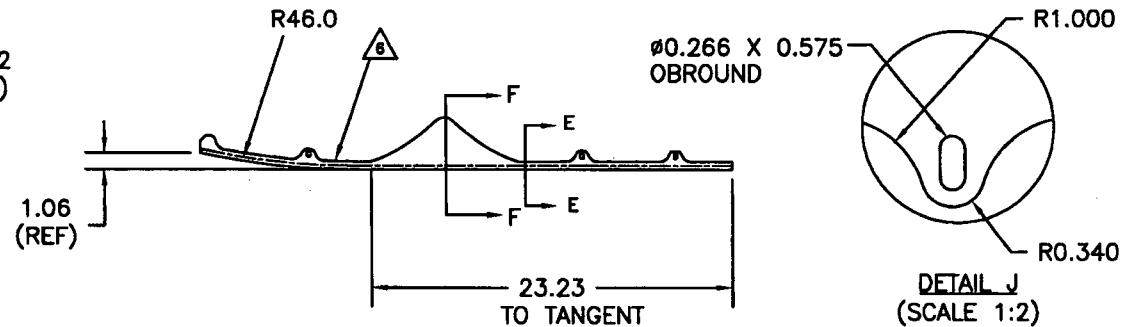


D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3)
- 4)
- 5)
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES
IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"



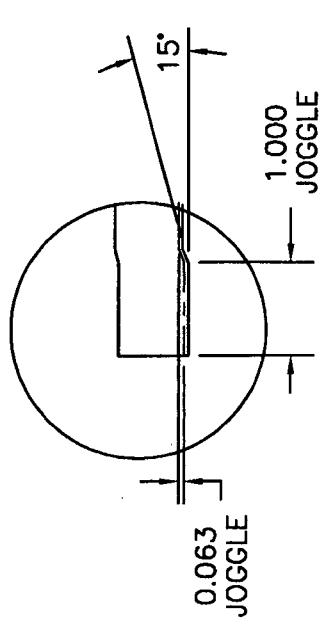
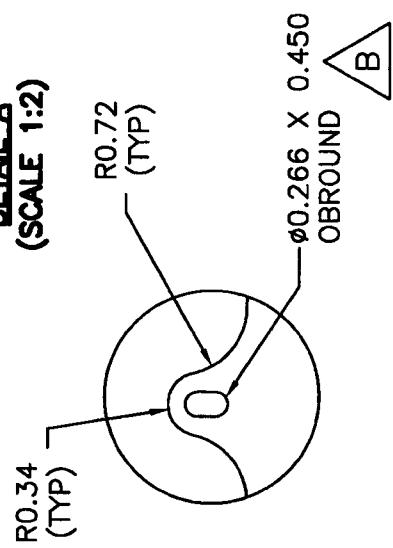
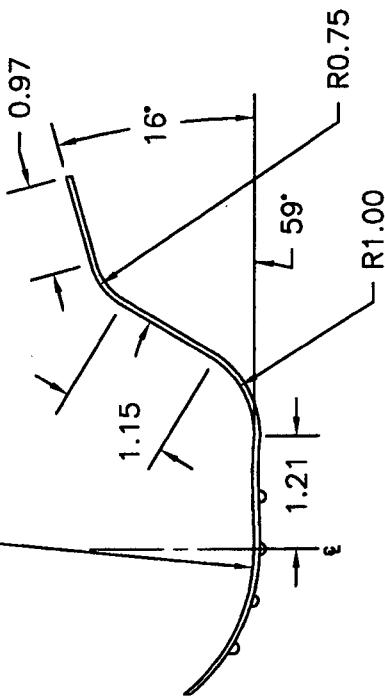
APPLY 7560 HARDCOAT WELD BEADS PER D3315-5T1 ON BOTTOM SURFACE AFTER FORMING (TYP), SEE SECTION E-E



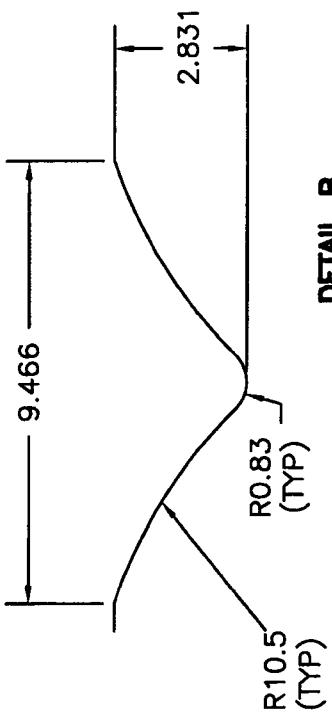
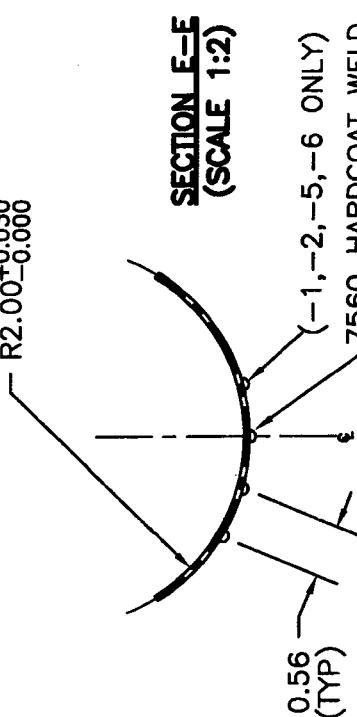
BENDING DETAIL

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initial]</i>	APPROVED <i>[initial]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)**DETAIL D**
(SCALE 1:2)R2.00^{+0.000}_{-0.000}**SECTION F-F**
(SCALE 1:2)

B

**DETAIL B**
(SCALE 1:4)R2.00^{+0.030}_{-0.000}**SECTION E-E**
(SCALE 1:2)RELEASED
06.03.20

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DART AEROSPACE LTD	Work Order:	36171
Description: WEAR SHOE	Part Number:	D3315-3
Inspection Dwg: D3315-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	IB	Audited by:	J.	Prototype Approval:	✓ /
Date:	07-12-10	Date:	02/12/10	Date:	1/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	